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TCS Satin™

[Overview](#)[Specifications](#)[Warranty](#)[► Installation](#)

TCS Satin

Installation Procedures For Flat-Lock (less than 3:12 pitch)

1. Make sure to use sheets no larger than 20" x 28".
2. Make sure that all edges of material roofing plates are single locked minimum of $\frac{3}{4}$ inch. To facilitate soldering it is recommended that the edges of sheets to be joined be pre-tinned.
3. Apply Follansbee's Speed flux to seam.
 - (a) Liquid rosin based fluxes are commercially available or Follansbee's Speed flux can be purchased through your local distributor.
 - (b) A small glue brush makes a good applicator. Care should be exercised to avoid dropping flux anywhere except where the soldering is to be done. Dip the brush in the flux and spread it lightly on the place to be soldered.
4. Use large coppers. (Soldering Irons)
 - (a) Six pounds per pair soldering irons are satisfactory but larger irons will aid in the additional heat required to solder TCS Satin.
 - (b) Electrical Soldering irons can be used providing they have adequate tip size and wattage for the job. (300-700 watts).
5. Heat coppers uniformly.
6. Clean coppers by dipping in hydrochloric acid flux. (Coppers should be properly tinned)
 - (a) Cover metal in areas where coppers are cleaned
 - (b) The spray caused when the iron is dipped to clean is exceptionally corrosive and will cause corrosion of the surface of most metals.
7. Use pure tin solder for TCS Satin
 - (a) The TCS Satin metal must have a bright and clear finish to make a well-bonded joint. A dull and dirty metal will not solder.
 - (b) Solder the TCS Satin metal.
8. Heat the seam close to the edge and apply solder. The position of the soldering iron is important because the iron does two things as it is applied to the TCS Satin metal:
 - (a) It heats the metal to the melting point of the solder.
 - (b) It heats the solder and keeps it in a liquid state while soldering.
 - (c) You must allow maximum heat transfer from the iron to the TCS Satin.
 - (d) Proper temperature and patience is required for a properly soldered seam. (e) A damp rag may be used to cool the soldered seams.
9. Reheat the seams behind the edge and add additional solder to sweat the seam full.
10. All flux, vapor and flux residue should be neutralized and removed. Sodium Bicarbonate (baking soda) is a good neutralizing solution. The neutralizing solution should be rinsed off with clean water.
11. The successful application of soldering TCS Satin depends upon several elements including:
 - (a) Properly tinned iron.
 - (b) Proper flux and application of flux
 - (c) Properly blended soldered.
 - (d) Correctly heated iron.
 - (e) Patience on the part of mechanic doing the soldering